

Work Order ID 72236

Page 1

Wednesday, July 20, 2011 9:07:03 AM

Item ID: D2829

Accept



Setup Start



Revision ID:

Stop



Item Name: Threaded Stud

Start Date: 7/20/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/07/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2829

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

SL 11/8/17

40 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/8/17

40 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

RP 11.8.17

40 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

GA

0.00



Packaging

Memo

0.00

Packaging

11/8/12

(40)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18

11-08-18
(40)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 9:07:01 AM

Page 1

Work Order ID: 72236



Parent Item: D2829



Parent Item Name: Threaded Stud


Start Date: 7/20/2011

Required Date: 7/27/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A 99.07.13 New Issue DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375  304 ROUND BAR 0.375		Purchased	No			110	f	14.4600	0.1	4.210526		11/18/11	

Location

MAT029

11/130

Loc Qty

14.46

14.46

Loc Code

11/18/11

4.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	72236
Description: Threaded Stud		Part Number:	D2829
Inspection Dwg: D2829 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1.037	/		SA-9	
0.50	+/-0.030	.50	/			
0.040	+/-0.010	.040	/			
0.50	+/-0.030	.50	/			
1/4-20 UNC-3A	Min: 0.2419 Max: 0.250	.246	/			
5/16-24 UNF-3A	Min: 0.3053 Max: 0.3125	.309	/			
MOW	0.2612-0.2584	.260	/			
MOW	0.3363-0.3336	.334	/			

Measured by: SA	Audited by: RP	Prototype Approval:	N/A
Date: 11/8/16	Date: 11-8-17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	DA

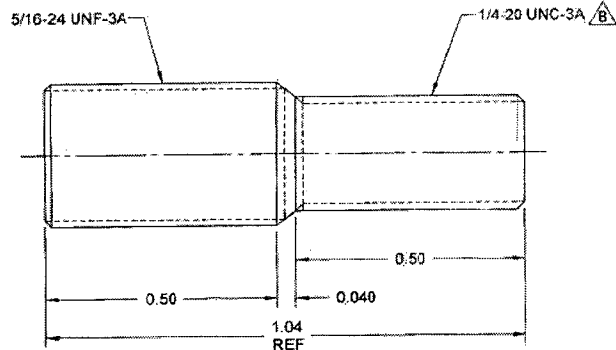
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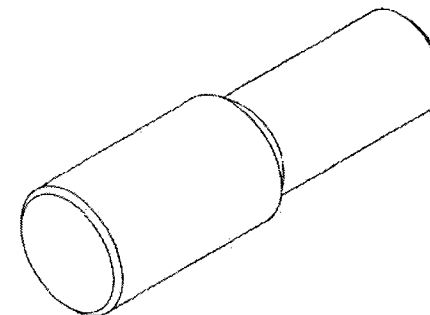
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D2829 THREADED STUD



RELEASED
06/10/27/10

CL11107/20
W10: 72236

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. D304RD.DDD
OR
AISI 303 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M303RD.DDD
- 2) FINISH: NONE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO 'B' SIZE FORMAT; MATERIAL WAS AISI 413M (Zn AB-1); 1/4-20 UNC-3A WAS 1/4-28 UNF-3A (Zn CS-1) REASON: REVISION OF D2011 FROM REV. F TO REV. G	MB	08.10.03
A	NEW ISSUE	RF	09.05.31
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2829** REV. B
SHEET 1 OF 1
TITLE **THREADED STUD** SCALE NTS

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